

Date: Wednesday, 14/05/2008 10:01:46 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BAR
 Job Number : 39259
 Estimate Number : 10389
 P.O. Number :
 This Issue : 14/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 14/05/2008 Type : MACHINED PARTS
 Previous Run : 30654
 Part Number : D31964
 Drawing Number : D3196 REVC
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 30/05/2008 Qty: 10 Um: Each
 Written By :
 Checked & Approved By : JLD 08.05.14
 Comment : Est Rev: A New Issue 05-11-08 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0750X01500 6061-T6 Bar .75" X 1.5"



Comment: Qty.: 3.0345 f(s)/Unit Total : 30.3450 f(s)
 Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8)
 (M6061T6B0.750x01.500)
 Identify for D3196-4
 Batch: M08118 mmf 08/05/24

(10)

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blank: (0.75" x 1.50") x 34.750" long Bar mmf 08/05/24

(10)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3196-4 as per Folio FA339 and Dwg D3196 Identify as D3196-4

2-Deburr

mmf 08/05/30

(10)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 08/05/30

(10)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

mmf 08/06/01 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 14/05/2008 10:01:46 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 39259

Part Number: D31964

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(10X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

mf / RB

08/06/02

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8:50

OVEN TEMPERATURE:

320°

FINISH TIME:

9:20

BL

08-06-03

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-06-03

(X10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

St247

Pc 8/6/3

(10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/04

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-06-04

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DART AEROSPACE LTD		Work Order:	39259
Description: Bar		Part Number:	D3196-4
Inspection Dwg: D3196	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.625	+/-0.010	34.625	✓			
33.650	+/-0.010	33.650	✓			
16.639	+/-0.010	16.639	✓			
0.488	+/-0.010	488	✓			
0.962	+/-0.005	962	✓			
0.464	+/-0.010	462	✓			
0.504	+/-0.010	502	✓			
Ø0.344	+0.006/-0.001	Ø.344	✓			
Ø0.660 x 100°	+0.008/-0.001 x 0.5°	Ø.660 x 100°	✓			
0.512	+/-0.005	513	✓			
0.060 x 45°	+/-0.010 x 0.5°	0.062 x 45°	✓			
4.750	+/-0.010	4.755	✓			
12.531	+/-0.010	12.531	✓			
16.627	+/-0.010	16.627	✓			
21.844	+/-0.010	21.844	✓			
29.625	+/-0.010	29.625	✓			
0.250	+/-0.010	250	✓			
1.000	+/-0.010	999	✓			
R0.125	+/-0.010	R.125	✓			
0.987	+/-0.010	992	✓			

Measured by: <i>mk</i>	Audited by: <i>DJP</i>	Prototype Approval:	N/A
Date: 08/05/30	Date: 08/05/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	
B	06.10.24	Dwg Rev. updated	KJ/JLM <i>JA</i>	<i>B</i>

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Dart Aerospace Ltd

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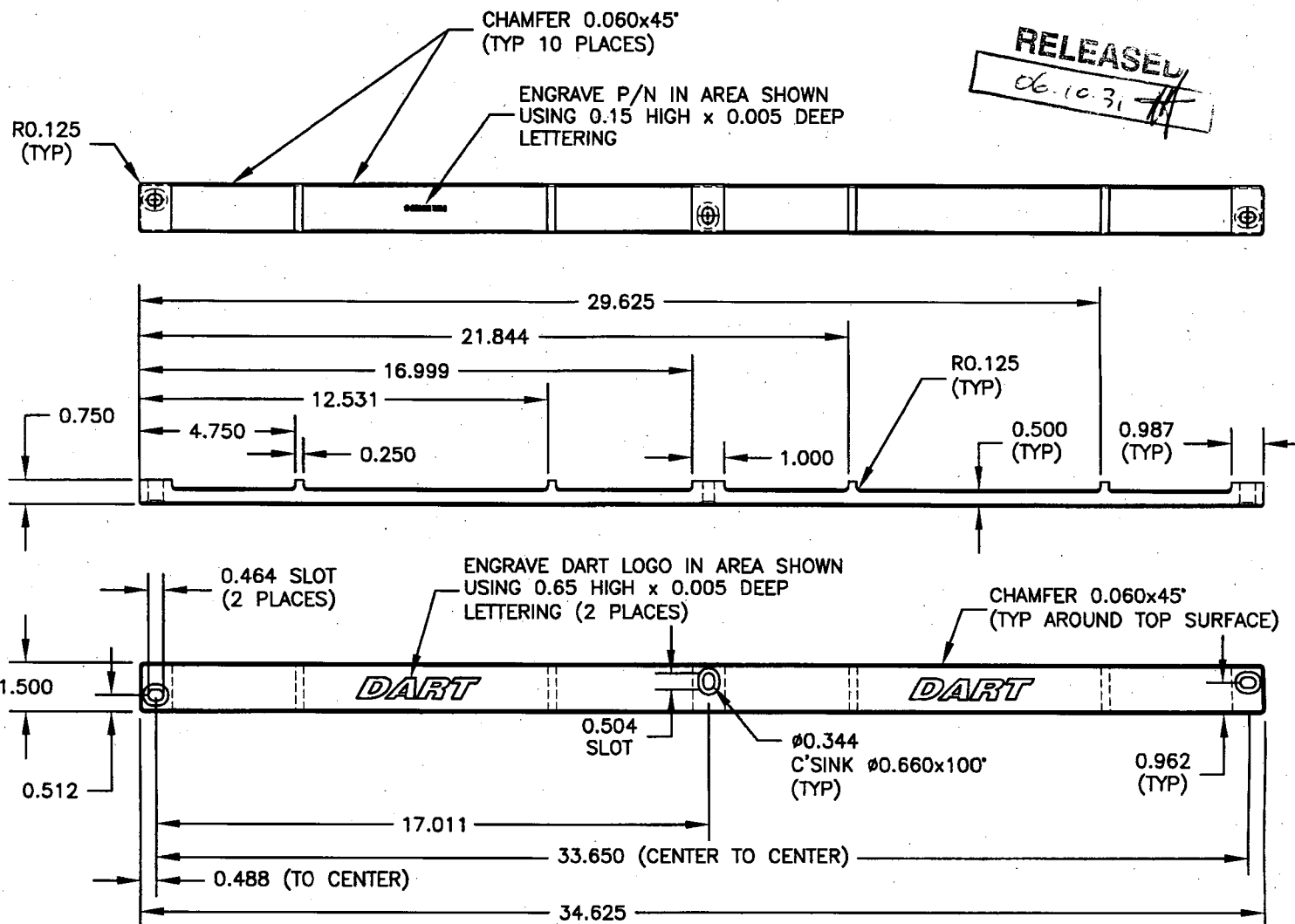
QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

RELEASED
06.10.31



D3196-3 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 36259

DESIGN	40	DRAWN BY	JS	DART AEROSPACE LTD	REV. C
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA	
DATE	06.10.31	TITLE	BAR	DRAWING NO.	D3196
				SHEET 2 OF 3	
				SCALE	1:5

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

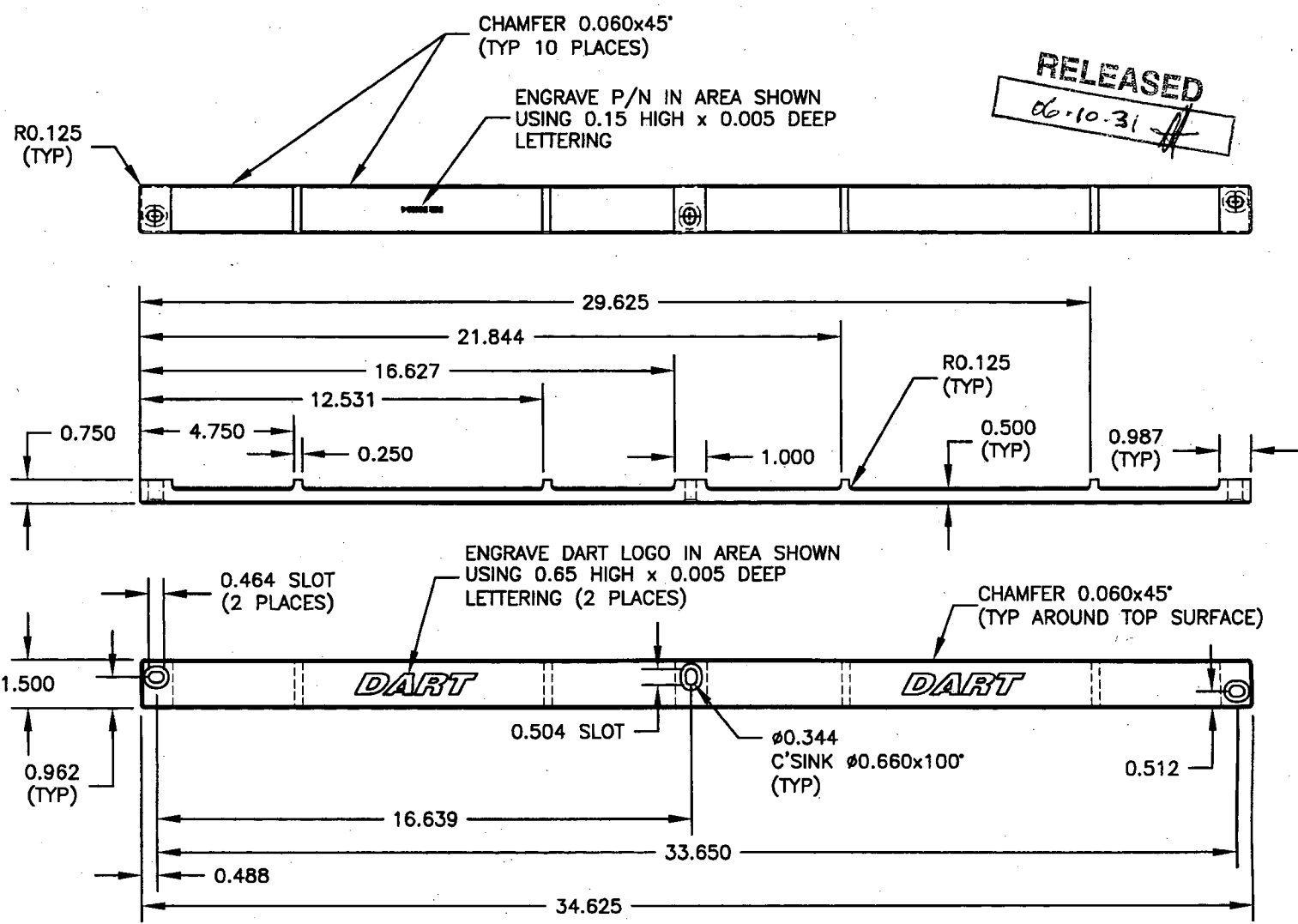
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DART

RELEASED
06-10-31



D3196-4 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
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WITHOUT NOTICE
WORK ORDER
NO. 39059

DESIGN	90	DRAWN BY		DART AEROSPACE LTD
CHECKED	PH	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.10.31	DRAWING NO.	D3196	REV. C
		TITLE	BAR	SHEET 3 OF 3
		SCALE	1:5	

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